



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁵ : A61F 13/15	A1	(11) International Publication Number: WO 94/10956 (43) International Publication Date: 26 May 1994 (26.05.94)
(21) International Application Number: PCT/SE93/00974 (22) International Filing Date: 15 November 1993 (15.11.93) (30) Priority data: 9203445-3 17 November 1992 (17.11.92) SE (71) Applicant (for all designated States except US): MÖLN- LYCKE AB [SE/SE]; S-405 03 Göteborg (SE). (72) Inventors; and (75) Inventors/Applicants (for US only) : WIDLUND, Urban [SE/SE]; Pärönvägen 5, S-435 43 Mölnlycke (SE). ÖS- TERDAHL, Eje [SE/SE]; Rödingsgatan 13, S-421 58 Västra Frölunda (SE). HANSSON, Roy [SE/SE]; Ale- gårdsgatan 112, S-431 45 Mölndal (SE). KOLAR, Milan [SE/SE]; Saturnusvägen 36, S-854 68 Sundsvall (SE).	(74) Agents: BJERNDELL, P. et al.; H. Albihns Patentbyrå, Box 3137, S-103 62 Stockholm (SE). (81) Designated States: AU, CA, CZ, FI, HU, JP, NO, NZ, PL, SK, US, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i>	
(54) Title: A METHOD FOR THE MANUFACTURING OF AN ABSORBENT STRUCTURE AND AN ABSORBENT AR- TICLE COMPRISING AN ABSORBENT STRUCTURE MANUFACTURED ACCORDING TO THIS METH- OD (57) Abstract <p>A method for manufacturing an absorbent structure in an absorbent article, such as a sanitary napkin, tampon, panty protector, incontinence guard, diaper, bed protector, wound or sore dressing, saliva absorbent and like articles is produced by using absorbent material in roll form directly in the product without first defibrating the material and then forming a mat. The material possesses good wicking properties and swelling properties, which are meaningful to the function of the product. A high surface dryness is obtained, among other things. In addition to cellulose fibres, the absorbent structure may also include superabsorbent material and/or binding fibres, among other ingredients. The pulp mat is very thin, therewith obviating the need to compress the mat further in the product. In the case of certain product applications, the material is softened mechanically prior to its use as an absorbent material.</p>		

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A METHOD FOR THE MANUFACTURING OF AN ABSORBENT STRUCTURE AND AN ABSORBENT ARTICLE COMPRISING AN ABSORBENT STRUCTURE MANUFACTURED ACCORDING TO THIS METHOD.

Background

The present invention relates to a method for manufacturing of an absorbent structure in an absorbent article, such as a sanitary napkin, a tampon, a panty protector, an incontinence guard, a diaper, a wound or sore dressing, a saliva absorbent and like articles.

Many different types of absorbent articles of this kind are known to the art. The absorbent bodies of such articles are typically produced by dry-defibering and fluffing cellulose pulp in roll, bale or sheet form for instance, to form a pulp mat, sometimes admixed with so-called superabsorbent material in the pulp mat, these absorbents being polymers which are capable of absorbing many times their own weight of water or body fluid.

The pulp body is often compressed so as to enhance its fluid-wicking ability and also in order to reduce pulp body bulk and therewith obtain an article which is as compact as possible.

The absorbent body may also include other constituents, for instance constituents which will improve its fluid-aquisition properties or its fluid-wicking properties, or which will increase its coherent strength, i.e. its coherency, and its ability to withstand deformation in use.

One serious drawback with products of this nature is found in the total absorption capacity of the articles and also in the fact that the articles will often leak long before their total absorption capacity has been fully utilized. Among other things, this is because the body fluid discharged by the wearer is unable to penetrate into the absorption material and to spread to hitherto unused areas of the article quickly enough, but instead leaks from the sides of the sanitary napkin, the diaper or the incontinence guard. The ability of the materials used in the article to disperse

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the absorbed fluid throughout the entire absorbent body is thus highly important.

Another problem resides in so-called rewetting, i.e. the transference of body fluid that has already been absorbed back into contact with the wearer's skin as a result of external forces, for instance when the wearer sits down. It is generally desired that the surface of the article that lies proximal to the wearer in use will remain as dry as possible.

Another desideratum with regard to the majority of hygiene products is that the article shall be thin, so that it can be worn as discretely as possible.

A very large part of the production plants used in the manufacture of the aforesaid hygiene articles is comprised of defibrating equipment, pneumatic conveying systems and mat-forming equipment. This equipment is also the source of serious faults in the production plants. Equipment for compressing the finished pulp mat or the finished hygiene product is furthermore often included downstream of the production plants.

A separate problem is related to the use of superabsorbent material in absorbent articles. The superabsorbent material is normally available in the form of granules, which are difficult to bind to the absorbent structure.

It is known from International Patent Application WO 90/05808 to produce a pulp web by dry-forming, which is later defibered, so-called dry-formed roll or reel pulp. Flash-dried paper-pulp fibres, which may consist of thermomechanical pulp, chemi-thermomechanical pulp, CTMP, or chemical paper pulp, sulphite or sulphate pulp with a dry solids content of about 80% is delivered by means of an air stream in a controlled flow to a forming head arranged above a forming wire and there formed into a web that has a surface weight of 300-1500 g/m² and a density of 550-1000 kg/m³. Air is sucked away through a suction box placed beneath the wire. The moisture content in the process shall be 5-30%.

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The web is pre-pressed to a density of 550-1000 kg/m³ in order to slightly reduce the bulk of the web prior to the final pressing stage. The pressed web has a mechanical strength which enables the web to be rolled-up or handled in sheet form for storage and transportation purposes. The web can be readily defibered and is intended to be converted into fluff for use in the manufacture of absorbent bodies or pads for diapers, sanitary napkins and like articles.

Another method for the manufacturing of an absorbent structure is described in European Patent 0 122 042, where a mixture of hydrophilic fibres and water insoluble particles of insoluble hydrogel is airlaid into a web and compressed to a density of 0.15 to about 1.0 g/cm³. This method however comprises several production steps, where the dry lap base material is first disintegrated into cellulose fibres by use of a hammer mill, whereafter the fibres are deposited on a screen surface and formed to the absorbent structure, which is then compressed. These manufacturing steps make this process rather complicated and expensive.

Summary of the Invention

The object of the present invention is to provide in an absorbent article of the aforescribed kind an absorbent structure which exhibits extremely good absorption properties, both with respect to its ability to quickly take up fluid and also with respect to its ability to spread fluid throughout the material. The material will preferably exhibit low rewetting tendencies as well as being capable of being made very thin. It is also desired to provide a simplified method of manufacturing absorbent articles of the kind defined in the introduction. These objects and desiderata are achieved with a manufacturing method in which particulate material comprising 30-100%, preferably at least 50% and most preferably at least 70% flash-dried cellulose fibres is dry-formed to a web with a surface weight of between 30-2000 g/m² and compressed to a density of between 0.2-1.0 g/cm³ and that the web without subsequent defibration and fluffing is incorporated as an absorbent structure in an absorbent article.

Non-defibered, dry-formed roll pulp has been found to be an extremely good absorption material and can be used directly as an absorbent material in hygiene articles, without being defibered. The material also has good fluid wicking properties and swelling properties, which are meaningful to the function of the product. The pulp mat is very thin and therefore need not be further compressed in the product or article.

In the case of certain product applications in hygiene articles, it is convenient to soften dry-formed roll pulp prior to its use as an absorption material. The earlier mentioned good absorption properties, fluid wicking properties and swelling properties are not influenced by the softening process to any great extent. One method to soften an absorbent sheet is described in European Patent Application EP 0 360 472, where the compressed absorbent material is worked between partially cutting rollers and thereby gaining softness. This method however leads among other things to decreased strength in the softened material.

Brief Description of the Drawings

The invention will now be described in more detail with reference to a number of exemplifying embodiments thereof and also with reference to the accompanying drawings, in which:

Figure 1 illustrates the absorption properties of a dry-formed CTMP-material subsequent to being worked between rolls at different roll spacings. Conventionally formed and compressed pulp mats of CTMP-pulp and chemical pulp respectively were used as references.

Figure 2 illustrates the absorption properties of a dry-formed CTMP-material subsequent to being softened. Conventionally formed and compressed mats comprised of CTMP-pulp and chemical pulp respectively were used as references.

Figure 3 illustrates the absorption properties of a complete absorbent article manufactured with dry-formed CTMP in the core.

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Conventionally manufactured products of corresponding compositions were used as references.

Figure 4 illustrates the fluid aquisition time of a complete absorbent article produced with dry-formed CTMP in the core. Conventionally manufactured products of corresponding compositions were used as references.

Figure 5 illustrates the degree of utilization of a complete absorbent article produced with dry-formed CTMP in the core. Conventionally manufactured products of corresponding compositions were used as references.

Figure 6 illustrates the absorption properties of an absorbent structure produced with dry-formed CTMP, both with and without a superabsorbent admixture. Conventionally manufactured pulp cores both with and without a superabsorbent admixture were used as references.

Figure 7 illustrates rewetting of a complete absorbent article produced with dry-formed CTMP in the core. Conventionally manufactured products of corresponding compositions were used as references.

Figure 8 illustrates the respective rewetting of an unsoftened and a softened absorbent structure in connection with blood absorption which was produced with dry-formed CTMP in the core, both with and without a superabsorbent admixture.

Figure 9 illustrates rewetting of a completely absorbent article in connection with blood absorption which was produced from dry-formed CTMP in the core. Conventionally manufactured products of corresponding composition were used as references.

Figures 10-14 illustrate schematically the composition of various exemplifying embodiments of inventive absorbent articles.

Figure 15 illustrates the structure of a cross section of the material in unsoftened condition.

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Figure 16 illustrates the structure of a cross section of the material in softened condition.

Description of the Invention

As before mentioned, important properties of a material used in the manufacture of a hygiene article are its absorbent capacity, absorption rate, wicking capacity, drainage capacity, retention capacity, rewetting, softness and smoothness.

The fluids concerned are urine, menstruation blood, blood, fluid matter from wounds and sores, rinsing fluid and saliva.

The object of the present invention is to provide in an absorbent article such as a sanitary napkin, tampon, panty protector, incontinence guard, diaper, bed protector, wound or sore dressing, saliva absorbent and like articles, an absorbent structure which exhibits highly effective absorption properties, both with regard to its fluid-aquisition rate and its ability to wick fluid throughout the material. The material will also preferably have low rewetting and be capable of being made very thin and smooth. It is also desired to simplify the manufacturing process. A finished absorbent material in roll form which can be used with-out needing to be defibered would partially reduce the need for the earlier mentioned defibering equipment, pneumatic conveying systems and mat-forming equipment, and consequently there is a demand for such material.

The aforesaid objects and desiderata have been achieved in accordance with the invention by using a manufacturing method in which particulate material comprising 30-100%, preferably at least 50% and most preferably at least 70% flash-dried cellulose fibres is dry-formed to a web with a surface weight of between 30-2000 g/m² and compressed to a density of between 0.2-1.0 g/cm³ and that the web without subsequent defibration and fluffing is incorporated as an absorbent structure in an absorbent article.

In accordance with the invention, there is used a dry-formed product which is manufactured from particulate material as

mechanical pulp or chemi-thermomechanical pulp (CTMP) or a corresponding product manufactured from sulphite pulp or sulphate pulp, so-called chemical cellulose pulp. Cellulose fibres which have been stiffened chemically may also be used. In the dry-formed product can also be included other particulate matter as superabsorbents, thermoplastic binding fibres and other kind of fibres.

Non-treated dry-formed roll pulp has extremely good absorption, wicking and swelling properties, and it has been found possible to use the material immediately as an absorption material in hygiene articles without defibrating the pulp. In the case of certain absorbent articles, it has been found suitable to soften the material slightly prior to its use. One method of softening the material is described below.

Dry-formed roll pulp has a good mat integrity which means that in the case of use of superabsorbent materials in dry-formed roll pulp the granules will be well bound to the absorbent structure and will not spread during further conversion into absorbent hygiene products.

Dry-formed cellulose pulp can be produced, for instance, by forming a web of flash-dried paper pulp fibres in accordance with the method described in International Patent Application WO 90/05808.

Cellulose pulp fibres have a so-called curl value which defines the crookedness of the fibre. Curl value can be measured according to the method described by B.D. Jordan, N.G. Nguyen in Papper och Trä 4/1986, page 313.

Softening of the Material

The material can be given a softness which renders the material highly suitable for use as an absorption material in the majority of hygiene articles, by working dry-formed roll pulp between for instance corrugated rolls. The material can be brought to different degrees of softness for different product applications, by working

the material between different types of rolls and at different roll spacings.

Dry-formed roll pulp which has been softened in this way exhibits very good product properties, and the earlier mentioned good absorption properties are not influenced by the softening process to any great extent.

The material is delaminated in the softening process as illustrated in figures 15 and 16. The unsoftened material has normally an even high density throughout the whole the thickness of the material (61). As a result of the softening process the material is delaminated so as to form a plurality of partially separated (63), thin fibre layers (62). Softening and delamination of the material reduces its total density to some extent, although the original density is essentially retained in each individual layer. Because a very high density is retained in the individual layers, the good fluid wicking properties of the material are retained despite the increase in bulk obtained in conjunction with the softening process. The total bulk is increased by up to 300%, normally 1-100%, as a result of the softening process, depending on the method used and the extent to which the material is softened.

It will be understood that the aforesaid material softening method has been given solely by way of example and that corresponding results can be achieved with the aid of other methods. For instance, the material could eventually be softened by means of ultrasonic energy, microwaves, by moisturizing the material, or with the aid of chemical additives.

Investigation of Material Properties

The test equipment described below was used to evaluate absorption properties.

Method 1. Absorption Properties Up an Inclined Plane

A rectangular test body was punched from the material and a line was drawn transversely across the test body at a point 11 cm from

one short end of the body. A fluid container was placed adjacent laboratory scales and both the scales and the container were adjusted to a horizontal position. A plexiglass plate was placed on the scales at a 30° slope, with one free edge of the plate extending slightly down into the container. A line had been drawn transversely across the plate at a point 11 cm from the lower edge of said plate. Test fluid (0.9% NaCl-solution) was poured into the container, until 20 mm of the plexiglass plate was located beneath the surface of the fluid. The test body was secured on the plexiglass plate so that the line drawn on the test body coincided with the line drawn on the plate while, at the same time, folding away the lower part of the test body so as to prevent it from coming into contact with the test liquid. A clock was started at the same time as the test body was laid onto the plate, with the test body extended down into the solution to the same extent as the plate. The increase in weight of the test body with time was recorded.

Method 2. Measurements of Absorption Capacity and Degree of Utilization

A test product was secured in a fixture. Test fluid (0.9% NaCl-solution) was delivered to the wetting point of the product over a period of 60 minutes at the rate at which the fluid was absorbed. The amount of fluid absorbed was measured continuously and the total amount of fluid absorbed by the product constitutes the utilized absorption capacity of the test product. The test product was then placed in a fluid bath, in which it had the maximum opportunity of absorbing test fluid. The test product was then again weighed and the total absorption capacity calculated. The degree of utilization is given by the quotient between the utilized absorption capacity of the test product and the total absorption capacity.

Method 3. Measurements of Rewetting, Fluid Wicking and Acquisition Time

Four batches of sample fluid (0.9% NaCl-solution), each comprising 28 ml, were delivered at 20-minute intervals. The time measurement

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was continued until all fluid had been absorbed. The extent to which the fluid had dispersed in the diaper was noted after each batch. Subsequent to delivering the last batch of fluid, filter paper was placed over the wetting point and loaded with a weight of 1.1 kg for 15 seconds. The filter paper was weighed both before and after applying the load and rewetting was recorded.

Method 4. Determining Rewetting Measurements

A diaper intended for a given weight range was weighed and then placed on a flat support surface. An adapted quantity of test fluid (0.9% NaCl-solution, 100 ml for a diaper intended for a weight range of 7-15 kg) was delivered to the wetting point of the diaper. A further 100 ml of fluid was delivered after 20 minutes. When all fluid had been absorbed, a filter paper was placed over the wetting point and loaded with a weight of 1.1 kg for 15 seconds. The filter paper was weighed both before and after applying the load and the result was recorded as a first rewetting instance. After a further 20 minutes, another 100 ml of fluid was delivered and when all fluid had been absorbed, the procedure was repeated with a fresh filter paper and the result recorded as a second rewetting instance.

Method 5. Determining Blood Absorption

A test body, 65 x 200 mm, was punched from the material. 5 ml test fluid (0.9% NaCl-solution) were delivered to the wetting point on the test body. Wicking of the fluid was measured after about 30 minutes. A further 5 ml of test fluid (0.9% NaCl-solution) were then delivered to the wetting point and fluid wicking was measured after about a further 30 minutes. Subsequent to the last delivery, eight filter papers were placed over the wetting point and loaded with a weight of 4.875 kg for 15 seconds. The filter papers were weighed both before and after applying the load and rewetting was recorded.

Test Results

Softening

With the intention of investigating how the material was affected at different softening roll spacings when softening the material, a material was tested under different softening conditions. For instance, in the case of a dry-formed CTMP-material having a surface weight of 900 g/m² and a density of 0.63 g/cm³, a suitable roll spacing is 1.7-2.4 mm during the softening process. The material is not influenced to any great extent at roll spacings which lie within this range. Figure 1 illustrates the absorption properties at different roll spacings. The results were determined in accordance with Method 1.

- A Material according to the invention, roll spacing 1.7 mm.
- B Material according to the invention, roll spacing 2.0 mm.
- C Material according to the invention, roll spacing 2.4 mm.
- D Material according to the invention, roll spacing 2.0 mm, softened twice.
- E Material according to the invention, roll spacing 2.0 mm, softened four times.
- F CTMP-pulp, density 0.125 g/cm³.
- G Chemical sulphate pulp, density 0.125 g/cm³.

Absorption Properties of Absorbent Structures

The absorption properties of an inventive CTMP-material having a surface weight of 900 g/m² and a density of 0.63 g/cm³ compared with those of corresponding pulp cores produced from conventionally defibred and web-formed CTMP and corresponding chemical pulp are shown in Figure 2. In the absence of superabsorbent material, the absorption capacity is about 9 g of fluid for each gram of absorbent material. The results were determined in accordance with Method 1.

- A Material according to the invention.
- B CTMP-pulp, density 0.125 g/cm³.
- C Chemical sulphate pulp, density 0.125 g/cm³.

Product Properties of a Complete Absorbent Article

With the intention of studying other properties of complete absorbent articles, test products were prepared in the form of conventional children's diapers which comprised a T-shaped absorbent body (T-core), which lies nearest the wearer, and a rectangular absorbent body (R-core) which lies beneath the T-core, where the rectangular absorbent body in the test products was produced from an inventive CTMP-material. In the conventional products, the T-shaped absorbent body (T-core) and the rectangular absorbent body (R-core) were comprised of conventional defibred CTMP and chemical pulp.

Measurements of the Absorption Capacity

Products which comprised an inventive CTMP-material exhibited an absorption in grams which was equivalent to the reference products which had corresponding pulp cores that were comprised of conventionally defibred and mat-formed CTMP and chemical pulp. The results are set forth in Figure 3. The results were determined in accordance with Method 2.

- A Reference diaper Libero Girl.
- B Reference diaper Libero Boy.
- C Child diaper comprising inventive material.

Measurements of Fluid Acquisition Time

Products in which the R-core comprised an inventive CTMP-material exhibited a shorter fluid acquisition time than the reference product. This implies that an R-core which contains inventive CTMP-material is able to drain the T-core more effectively. The results can be seen from Figure 4. The results were determined in accordance with Method 3.

- A Reference diaper Libero Girl.
- B Reference diaper Libero Boy.
- C Child diaper comprising inventive material.

Measurements of the Utilization of the Absorbent Body

A comparison between the degree of utilization of the absorbent body in an absorbent article which contained an inventive CTMP-material and a corresponding absorbent article which contained conventional CTMP and chemical pulp showed that the degree of utilization is about the same, although slightly on the plus side for an inventive CTMP-material. The results can be seen from Figure 5. The results were determined in accordance with Method 2.

- A Reference diaper Libero Girl.
- B Reference diaper Libero Boy.
- C Child diaper comprising inventive material.

Admixing Superabsorbent Material

The presence of superabsorbent material in an absorbent body will influence the absorption properties of the body. Superabsorbent material can be incorporated in the absorbent body in different ways. For instance it may be admixed with the body material, laid in layers in the body, or disposed therein in some other way. This admixture of superabsorbent material can be effected in conjunction with manufacturing the dry-formed material, although it may also be effected during some other part of the manufacturing process. The absorption properties were compared with an inventive CTMP-material to which no superabsorbent material had been added and also with corresponding pulp cores comprised of conventional defibred CTMP and chemical pulp. The results of this comparison are shown in Figure 6. The results were determined in accordance with Method 1.

- A Chemical sulphate pulp containing 30% superabsorbent and having a density of 0.125 g/cm³.
- B Inventive material containing 30% superabsorbent.
- C Reference diaper containing 30% superabsorbent.
- D Inventive material containing no superabsorbent.

Rewetting Measurements

Products which comprised an inventive CTMP-material in the R-core exhibited better rewetting values than the reference product. This

also implies that an R-core which contains inventive CTMP-material is able to drain the T-core more effectively. The results can be seen from Figure 7. The results were determined in accordance with Method 4.

- A Reference diaper Libero Girl.
- B Reference diaper Libero Boy.
- C Child diaper comprising inventive material.

Rewetting Measurements, Specific for Blood Absorption

In the case of blood absorption, products which comprised an inventive softened CTMP-material showed better rewetting values than non-softened products. The results also showed that when absorbing blood, products which lacked superabsorbent material exhibited lower rewetting values than material which contained superabsorbent material. Material which lacks superabsorbent material also wicks blood much more effectively. The results can be seen from Figures 8 and 9. The reference products comprised two different products frequently found on the market. The results were determined in accordance with Method 5. The prerequisites for this effect are that at least one layer of the pulp mat is free from superabsorbent material. Of course, this does not exclude the presence of such material in other parts of the absorbent article.

Figure 8

- A Inventive material 350 g/m².
- B Inventive material 350 g/m², softened.
- C Inventive material 350 g/m² + 5% superabsorbent.
- D Inventive material 350 g/m² + 5% superabsorbent, softened.

Figure 9

- A Reference product 1.
- B Reference product 2.
- C Product containing inventive material.

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Network Strength

Dry-formed roll pulp will normally have sufficient mat strength for the product applications intended here. If the network strength of certain product applications should be found insufficient, the network strength can be increased by reinforcing the structure in some suitable manner, by adding reinforcing fibres, binding fibres or binding agent to the cellulose fibre mixture. The network strength can also be increased by incorporating a reinforcing layer of, for instance, plastic, non-woven, net or threads in the absorbent structure, or by fastening a reinforcing layer or an outer sheet on one or both sides of the material.

Density and Surface Weight

The softened pulp mat is still very thin, and consequently it is unnecessary in many cases to further compress the mat prior to its use in an absorbent article. A suitable density is 0.2-1.0 g/cm³, preferably 0.25-0.9 g/cm³ and most preferably 0.3-0.85 g/cm³. A suitable surface weight is between 30-2000 g/m², preferably 50-1500 g/m² and most preferably 100-1000 g/cm². When calculating the density, the thickness of the material was measured with the aid of a Mitutoyo thickness meter.

Description of a First Exemplifying Embodiment

Figure 10 illustrates a diaper constructed in accordance with one embodiment of the invention. The diaper includes, in a conventional manner, an absorbent body 11 which is enclosed between a fluid-permeable top sheet 12, which conveniently comprises a soft non-woven material, a perforated plastic film or the like and which is intended to lie proximal to the wearer in use, and a fluid-impermeable bottom sheet 13. The sheets 12 and 13 have parts which extend beyond the absorbent body 11 and the sheets are joined together at these protruding parts. The bottom sheet 13 is comprised of a suitable plastic material, for instance polyethylene. It will be understood, however, that other known materials can be used for the top and bottom sheets, within the scope of the invention.

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The absorbent body is comprised of two or more layers, an upper fluid acquisition layer 14 and one or two lower wicking layers and storage layers 15 and 16. The inventive material can be used either as an acquisition layer 14, a wicking layer 15 or a storage layer 16 or as several of these layers. Those layers in which inventive material is not used may be comprised of other types materials, for instance conventional cellulose fibre material.

The purpose of the acquisition layer 14 is to rapidly take-up a given quantity of fluid. This fluid shall solely be held loosely in the fibre structure and quickly drained therefrom. The acquisition layer 14 is comprised of dry-formed material in accordance with the invention and has a relatively open fibre structure of relatively low density and contains 0-10% superabsorbent material. The superabsorbent material used in the acquisition layer 14 will preferably have a high gel strength, so that an open three-dimensional fibre structure will be retained in this layer after becoming wet. A suitable density range for the acquisition layer 14 is 0.2-0.8 g/cm³. A suitable surface weight range for the acquisition layer 14 is 50-1200 g/m².

The main purpose of the wicking layer 15 is to transport the fluid received in the acquisition layer 14 effectively to the storage layer 16 located beneath the wicking layer 15 and to ensure that the greatest possible part of the storage layer 16 is utilized for absorption purposes. The wicking layer 15 therefore has a relatively low superabsorbent content. A suitable superabsorbent content in the case of the wicking layer 15 is 0-20%, while a suitable density range is 0.25-1.0 g/cm³. A suitable surface weight range in the case of the wicking layer 15 is 50-1500 g/m².

The purpose of the storage layer 16 is to absorb and bind the fluid which is dispersed to the storage layer 16 through the wicking layer 15. The storage layer 16 may therefore have a relatively high superabsorbent content and a relatively high density. Suitable density values are 0.25-1.0 g/cm³, while a suitable superabsorbent content is 30-70%. A suitable surface weight range in the case of the storage layer 16 is 50-1500 g/m².

The wicking layer 15 and the storage layer 16 may optionally be combined to form a single layer. In this case, the single layer will have a relatively high superabsorbent content and a relatively high density. Suitable density values are 0.25-1.0 g/cm³, while a suitable superabsorbent content is 20-70%. A suitable surface weight range in the case of a combined wicking and storage layer is 100-2000 g/m².

When the wicking layer 15 and the storage layer 16 are combined in a single layer, the superabsorbent content of the layer can be varied throughout the product, so as to obtain a superabsorbent gradient in the depth, length and/or the breadth direction of the product.

The various layers may have different forms and sizes. Normally, the absorbent structure is combined with some form of elasticsation, inter alia in the crotch region of the product, in order to improve product efficiency.

Description of a Second Exemplifying Embodiment

Figure 11 illustrates an exemplifying embodiment of an inventive sanitary napkin. The napkin comprises conventionally an absorbent body 21 which is enclosed between a fluid-permeable top sheet 22, which is suitably comprised of perforated plastic film or like material and which lies proximal to the wearer in use, and a fluid-impermeable bottom sheet 23. A thin fluid-permeable layer 27, for instance of non-woven material, may be placed between the absorbent body 21 and the top sheet 22. The sheets 22 and 23 have parts which protrude beyond the absorbent body 21 and the sheets are mutually joined at these protruding parts. The bottom sheet 23 is comprised of a suitable plastic material, for instance polyethylene. It will be understood, however, that other known materials may be used for the top and the bottom sheets within the scope of the invention.

The absorbent body 21 is comprised of one single layer. This layer may consist of a dry-formed material according to the invention which contains from 0-10% superabsorbent material. A suitable

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density range in the case of the absorbent body 21 is 0.6-0.9 g/cm³, while a suitable surface weight is 200-300 g/m². When the absorbent body is comprised of a CTMP-material or some other material having a yellowish or brownish colour, a covering layer of chemical pulp white in colour may be applied to the top of the absorbent body.

Description of a Third Exemplifying Embodiment

Figure 12 illustrates an exemplifying embodiment of an inventive tampon. The tampon is comprised of an inventive absorbent material which has been rolled to a cylinder-like form 31. In conjunction with rolling the absorbent material into its cylindrical shape, a string 38 is placed in the centre of the cylinder 31, in a conventional manner, and the cylinder 31 is compressed to the desired thickness and shape, in a conventional manner. Prior to being compressed and shaped, the absorbent material will suitably have a density range of 0.4-0.9 g/cm³ and a suitable surface weight of 200-600 g/m².

Description of a Fourth Exemplifying Embodiment

Figure 13 illustrates an exemplifying embodiment of an inventive wound or sore dressing. The dressing includes, in a conventional manner, an absorbent body 41 which is enclosed between a fluid-permeable top sheet 42, which is suitably comprised of a soft non-woven material, a perforated plastic film or the like, and which is intended to lie proximal to the wearer in use, and a fluid-repellent bottom sheet 43. The sheets 42 and 43 have parts which protrude beyond the absorbent body 41 and are joined together at these protruding parts. The bottom sheet 43 is comprised of a suitable fluid-repellent material, for instance a non-woven material that has been made hydrophobic. It will be understood, however, that the top and bottom sheets may comprise other known materials, within the scope of the invention.

The absorbent body 41 is comprised of only one single layer. This layer may consist of inventive dry-formed material and may be constructed with a relatively open fibre structure of relatively

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low density and with a superabsorbent content of 0-10%. A suitable density range in respect of the absorbent body 41 is 0.2-0.5 g/cm³ and a suitable surface weight is 200-700 g/m².

Description of a Fifth Exemplifying Embodiment

Figure 14 illustrates an exemplifying embodiment of an inventive saliva absorbent. The saliva absorbent includes, in a conventional manner, an absorbent body 51 which is enclosed between a fluid-permeable top sheet 52, which is suitably comprised of a perforated plastic film or like material and which is intended to lie proximal to the wearer when used, and a fluid-impermeable bottom sheet 53. The bottom sheet 53 is comprised of a suitable plastic material, for instance polyethylene. It will be understood, however, that the top sheet 52 and the bottom sheet 53 may be comprised of other known materials within the scope of the invention.

The absorbent body 51 is comprised solely of one single layer. This layer may be comprised of inventive dry-formed material and has a relatively high density and a superabsorbent content of 20-80%. A suitable density range in respect of the absorbent body 51 is 0.4-0.8 g/cm³.

It will be understood that the invention is not restricted to the illustrated and described exemplifying embodiments thereof and that other embodiments are conceivable within the scope of the following Claims. The invention is not restricted for use in hygiene articles but can also be used to absorb water or other liquids.

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Claims

1. A method for the manufacturing of an absorbent structure in an absorbent article, such as a diaper, sanitary napkin, tampon, panty protector, incontinence guard, bed protector, wound or sore dressing, saliva absorbent and like articles, c h a r a c t e - r i z e d in that particulate material comprising 30-100%, preferably at least 50% and most preferably at least 70% flash-dried cellulose fibres is dry-formed to a web with a surface weight of between 30-2000 g/m² and compressed to a density of between 0.2-1.0 g/cm³ and that the web without subsequent defibration and fluffing is incorporated as an absorbent structure in an absorbent article.
2. A method for the manufacturing of an absorbent structure according to Claim 1, c h a r a c t e r i z e d in that said web is compressed to a density of between 0.25-0.9 g/cm³, preferably 0.3-0.85 g/cm³.
3. A method for the manufacturing of an absorbent structure according to one or more of Claims 1 or 2, c h a r a c t e - r i z e d in that the web in connection to the compression has a moisture content of between 3-20%, preferably between 4-18% and most preferably 11-16% calculated on the total weight of the web.
4. A method for the manufacturing of an absorbent structure according to one or more of the preceding Claims, c h a - r a c t e r i z e d in that the web before being incorporated as an absorbent structure in an absorbent article, such as a diaper, sanitary napkin, tampon, panty protector, incontinence guard, bed protector, wound or sore dressing, saliva absorbent and like articles is mechanically softened and therewith delaminated, so as to exhibit a plurality of partially separated thin fibre layers.
5. An absorbent structure c h a r a c t e r i z e d in that it has been manufactured according to the method claimed in one of more of Claims 1-4.
6. An absorbent structure manufactured according to Claim 5,

c h a r a c t e r i z e d in that the surface weight of the structure is between 50-1500 g/m², preferably 100-1000 g/m².

7. An absorbent structure according to Claims 5 or 6, c h a r a c t e r i z e d in that the cellulose fibres are mainly comprised of fibres of chemi-thermomechanically produced pulp.
8. An absorbent structure according to Claim 7, c h a - r a c t e r i z e d in that the chemi-thermomechanical pulp fibres have a curl value of between 0.20 and 0.40.
9. A n absorbent structure according to one or more of Claims 5-6, c h a r a c t e r i z e d in that the cellulose fibres are mainly comprised of fibres of chemically produced pulp.
10. An absorbent structure according to one or more of Claims 5-9, c h a r a c t e r i z e d in that at least an amount of the fibres are chemically stiffened cellulose fibres.
11. A n absorbent structure according to one or more of Claims 5-10, c h a r a c t e r i z e d in that the structure includes between 0.5-70% superabsorbent material, preferably between 2-50%, and most preferably 5-30%, calculated on the total weight of the structure in a dry state.
12. An absorbent structure according to one or more of the preceding Claims, c h a r a c t e r i z e d in that the structure includes reinforcing means, for instance binding agent, reinforcing fibres or thermoplastic binding fibres.
13. An absorbent structure according to one or more of the preceding Claims, c h a r a c t e r i z e d in that the structure includes a reinforcing layer of non-woven, tissue, plastic or net material for instance.
14. An absorbent article such as a diaper, sanitary napkin, panty protector, incontinence guard, bed protector, wound or sore dressing, saliva absorbent and like articles comprising a liquid-permeable top sheet, an essentially liquid-impermeable

bottom sheet, and an absorbent body enclosed between said sheets, characterized in that the absorbent body includes an absorbent structure according to one or more of Claims 5-13.

15. An absorbent article according to Claim 14, in which the absorbent body includes at least two layers, a acquisition layer and one or more wicking and/or storage layers, wherein the acquisition layer is intended to quickly take up and deliver fluid to the wicking and/or storage layer or layers, characterized in that the acquisition layer comprises an absorbent structure according to Claim 5 having a surface weight of between 50-1500 g/m² and a density of between 0.2-0.8 g/cm³.

16. An absorbent article according to Claim 15, characterized in that the cellulose fibres are comprised mainly of fibres of chemi-thermomechanically produced pulp.

17. An absorbent article according to Claim 16, characterized in that the absorbent structure is covered with a layer of chemical pulp on one side thereof.

18. An absorbent article according to one or more of Claims 15-17, characterized in that at least an amount of the cellulose fibres in the acquisition layer are chemically stiffened cellulose fibres.

19. An absorbent article according to one or more of Claims 15-18, characterized in that the density of the acquisition layer is between 0.2-0.7 g/cm³, preferably between 0.3-0.6 g/cm³.

20. An absorbent article according to one or more of Claims 15-19, characterized in that the surface weight of the acquisition layer is between 50-1200 g/m², preferably between 80-1000 g/m².

21. An absorbent article according to Claim 14, in which the absorbent body includes two or three layers, one acquisition layer and one or two wicking and storage layers, wherein the acquisition layer is intended to quickly take up fluid and deliver fluid to the

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wicking layer, c h a r a c t e r i z e d in that the wicking layer comprises an absorbent structure according to claim 5 having a surface weight of between 50-1500 g/m² and a density of between 0.25-1.0 g/cm³.

22. An absorbent article according to Claim 21, c h a r a c t e r i z e d in that the wicking layer is mainly comprised of fibres of chemi-thermomechanically produced pulp.

23. An absorbent article according to Claim 21, c h a r a c t e r i z e d in that the wicking layer is mainly comprised of fibres of chemically produced pulp.

24. An absorbent article according to one or more of Claims 21-23, c h a r a c t e r i z e d in that the density of the wicking layer is between 0.3-1.0 g/m³, preferably between 0.3-0.9 g/cm³.

25. An absorbent article according to one or more of Claims 21-25, c h a r a c t e r i z e d in that the wicking layer includes between 0-40%, preferably between 5-20% superabsorbent material.

26. An absorbent article according to Claim 21, c h a r a c t e r i z e d in that the article has been mechanically softened and the absorbent structure in the article therewith delaminated, so that said structure exhibits a plurality of partially separated thin fibre layers.

27. An absorbent article according to Claim 14, in which the absorbent body includes two or three layers, a aquisition layer and one or two wicking and storage layers, wherein the aquisition layer is intended to quickly take up fluid and deliver fluid to the wicking layer for further transportation to the storage layer, c h a r a c t e r i z e d in that the storage layer is comprised of an absorbent structure according to claim 5 having a surface weight of between 50-1500 g/m² and a density of between 0.25-1.0 g/cm³.

28. An absorbent article according to Claim 27, characterized in that the cellulose fibres are comprised mainly of fibres of chemi-thermomechanically produced pulp.
29. An absorbent article according to Claim 27, characterized in that the storage layer is mainly comprised of fibres of chemically produced pulp.
30. An absorbent article according to one or more of Claims 27-29, characterized in that the density of the storage layer is between 0.3-0.9 g/cm³, preferably between 0.4-0.8 g/cm³.
31. An absorbent article according to one or more of Claims 27-30, characterized in that the surface weight of the storage layer is between 80-1200 g/m² and preferably between 100-1000 g/m².
32. An absorbent article according to one or more of Claims 27-31, characterized in that the storage layer contains between 20-70%, preferably between 25-60% and most preferably 30-50% superabsorbent material.
33. An absorbent article according to Claim 14, intended for absorbing blood, such as a sanitary napkin, panty protector or wound or sore dressing, characterized in that the absorbent structure is comprised mainly of fibres of chemi-thermomechanically produced pulp and between 0-15% superabsorbent material, calculated on the total weight of the structure in a dry state.
34. An absorbent article according to Claim 33, characterized in that the absorbent structure contains no superabsorbent material.
35. An absorbent article according to any one of Claims 33 and 34, characterized in that the structure is covered with a layer of chemical pulp on one side thereof.

36. An absorbent article intended for absorbing blood, such as a tampon or like article, c h a r a c t e r i z e d in that the article includes an absorbent structure according to Claim 14.

37. An absorbent article according to Claim 36, c h a r a c t e r i z e d in that the absorbent structure is mainly comprised of fibres of chemi-thermomechanically produced pulp; and in that the article includes between 0-15% superabsorbent material, calculated on the total weight of the structure in a dry state.

38. An absorbent article according to Claim 37, c h a r a c t e r i z e d in that the absorbent structure contains no superabsorbent material.

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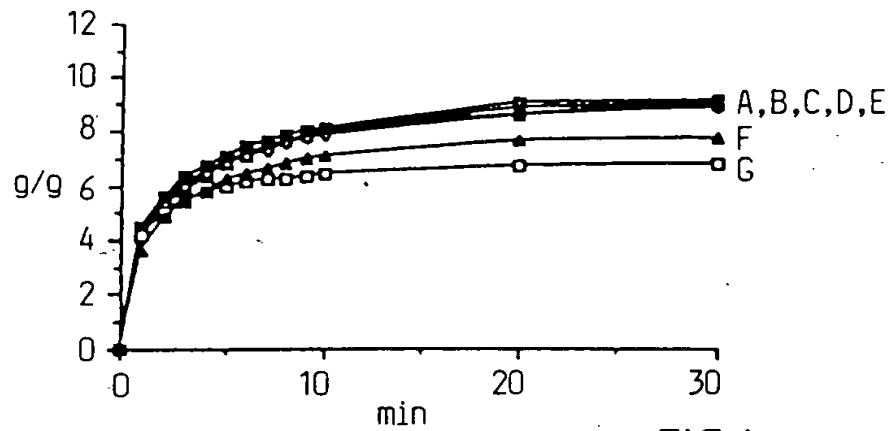


FIG. 1

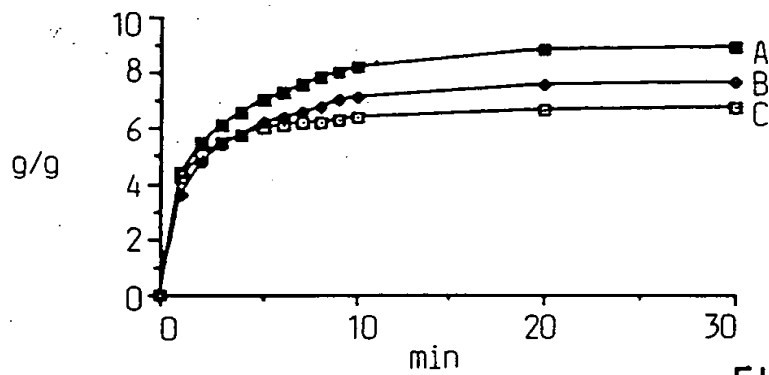


FIG. 2

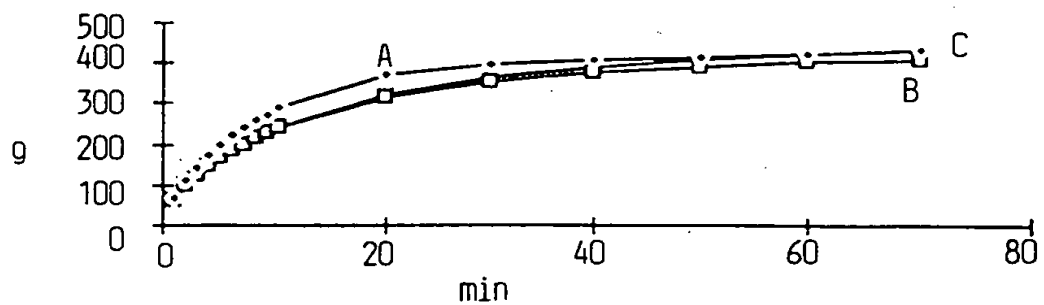


FIG. 3

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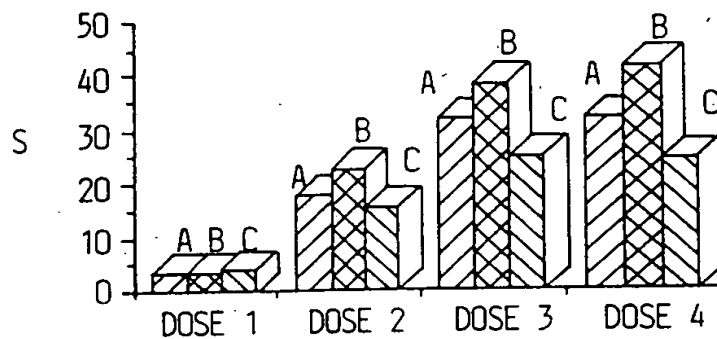


FIG. 4

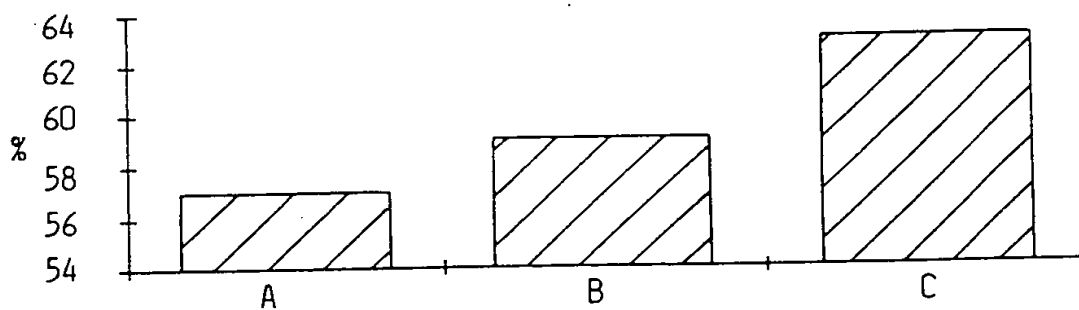


FIG. 5

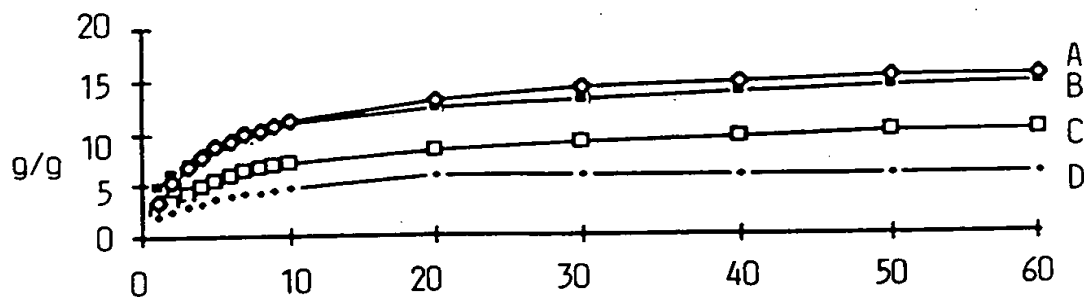


FIG. 6

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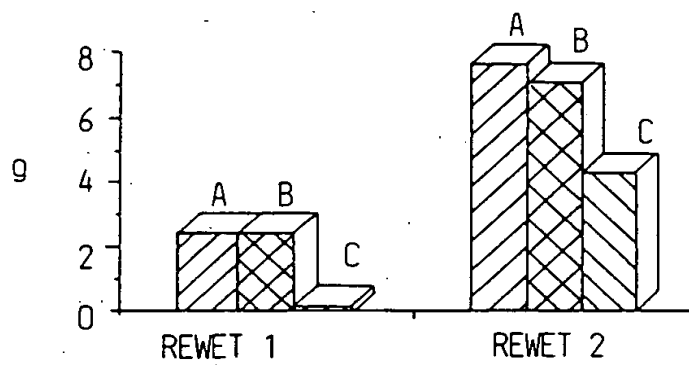


FIG.7

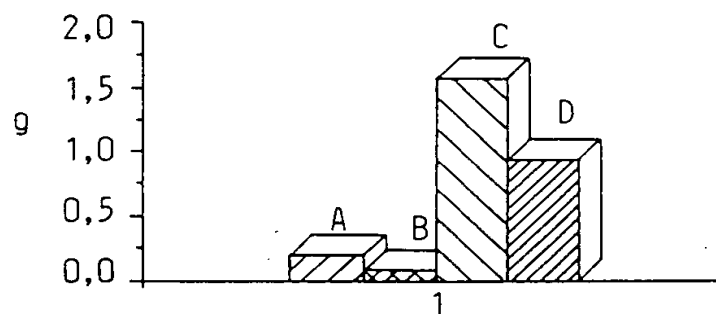


FIG.8

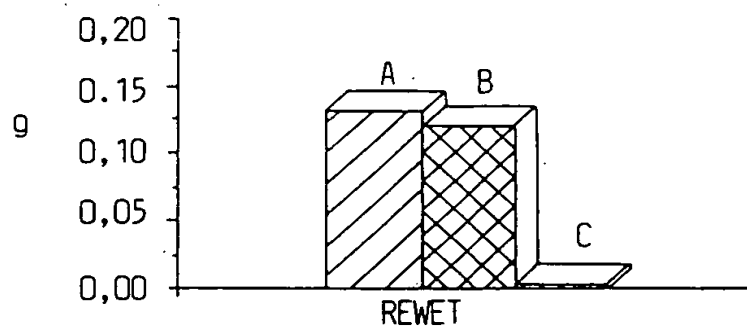


FIG.9

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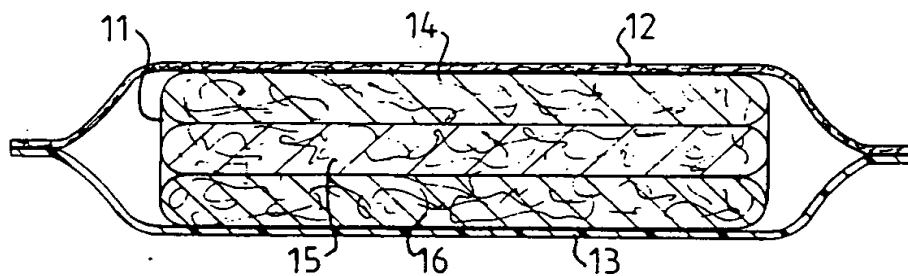


FIG. 10

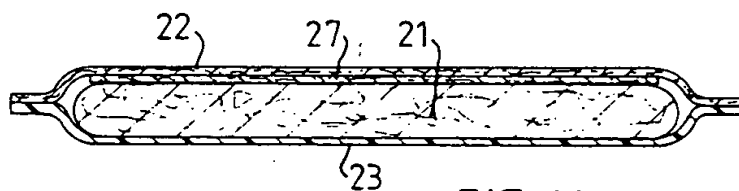


FIG. 11

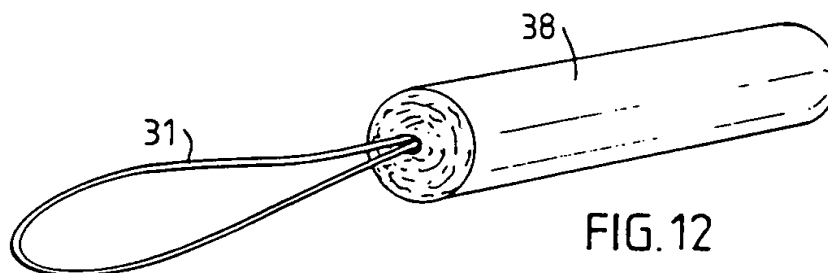


FIG. 12

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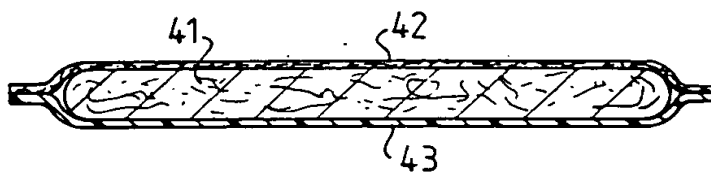


FIG. 13

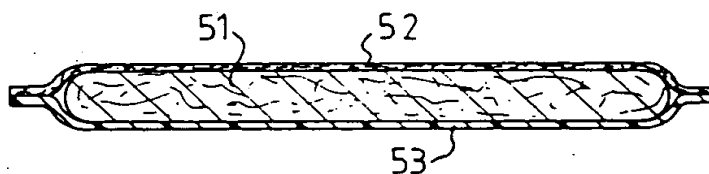


FIG. 14

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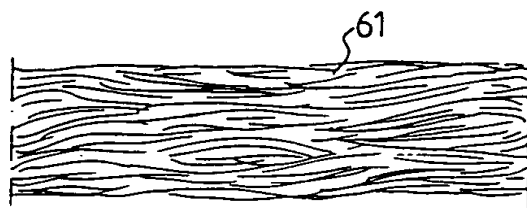


FIG. 15

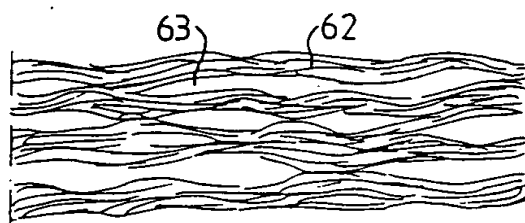


FIG. 16

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INTERNATIONAL SEARCH REPORT

1

International application No.

PCT/SE 93/00974

A. CLASSIFICATION OF SUBJECT MATTER

IPC5: A61F 13/15

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC5: A61F, D21H, D06C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO, A1, 9005808 (SCA PULP AB), 31 May 1990 (31.05.90)	1-37
A	US, A, 4610678 (PAUL T. WEISMAN ET AL), 9 Sept 1986 (09.09.86)	1-37

☐ Further documents are listed in the continuation of Box C.

☒ See patent family annex.

* Special categories of cited documents:

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"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

23 February 1994

Date of mailing of the international search report

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INTERNATIONAL SEARCH REPORT

Information on patent family members

28/01/94

International application No.

PCT/SE 93/00974

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
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